

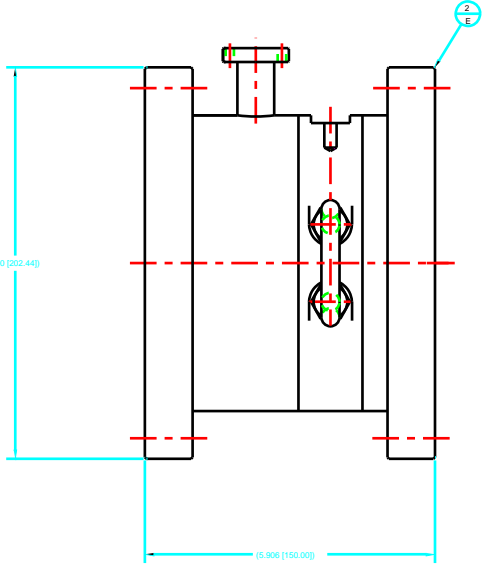
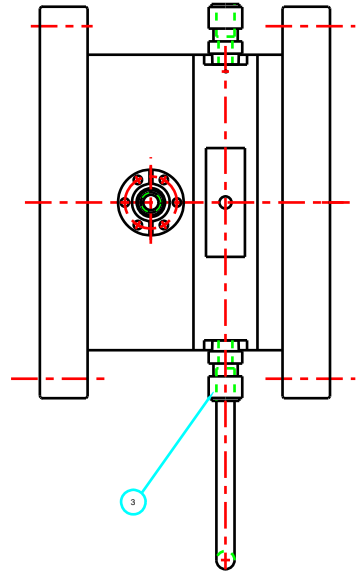
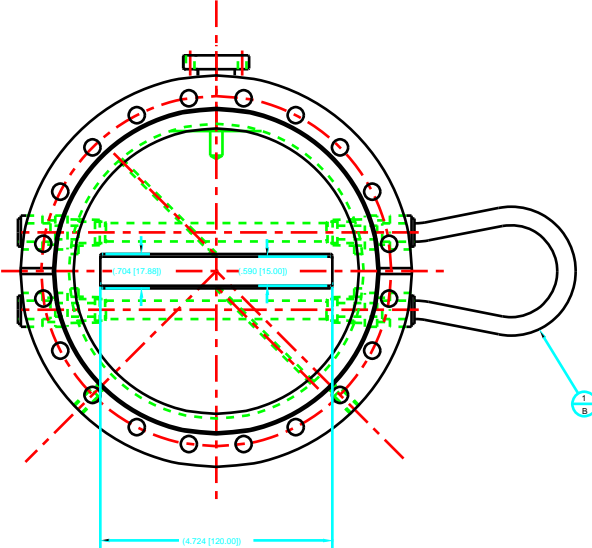
P4105090804-200100-00/A19149  
P4105090804-200101-00/A19151  
P4105090804-200102-00/A19152  
P4105090804-200103-00/A20887  
P4105090804-200105-00/A20888  
P4105090804-200106-00/A20889  
P4105090804-200107-00/A20900  
P4102020106-200001-00/A13481

NOTES:  
1. THIS IS A UHV ASSEMBLY. KEEP THE UHV PARTS CLEAN DURING ASSEMBLY AND WRAP UP FOR PACKING WITH ALUMINUM FOIL.

2. DEVICE SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10<sup>-10</sup> STANDARD CCSEC PER LEAK METER DIVISION, SUCH AS:  
ALCATEL ASM-110TCL  
VARIAN NCR 925 OR 936  
VEECO MSA-8, MS-90 OR MS-18  
DUPONT CEC 24-1208  
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.  
FINAL TEST WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

3. BEFORE ASSEMBLY OF SWAGelok MALE CONNECTORS, USE SILVER COOP THREAD LUBRICANT (FROM SWAGelok CO.) TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.  
4. ALL DIMENSIONS WITH ( ) ARE MILLIMETERS AND FOR REF. ONLY  
5. WATER PRESSURE TEST AT 500 PSI AFTER ASSEMBLING.

INSTRUCTIONS FOR INSTALLATION OF TUBING  
1. INSTALL THE TUBE INTO THE FITTING UNTIL IT IS BOTTOMED AGAINST THE SHOULDER OF THE BODY.  
2. TIGHTEN NUT TO APPR. 1/8 TURN PAST FINGER TIGHT.  
3. SCRIBE A LINE ON NUT AT 6 O'CLOCK.  
4. HOLDING THE FITTING WITH A WRENCH, TIGHTEN NUT PAST ONE COMPLETE TURN AND STOP TURNING WHEN SCRIBE MARK IS AT 9 O'CLOCK. (1-1/4 TURN)  
5. SUFFICIENT PULL-UP IS REACHED WHEN SWAGelok GAP INSPECTION GAGE (MS-IG-468) DOES NOT FIT INTO GAP BETWEEN NUT AND BODY.



**SOURCE**  
(SWAGelok)  
DEARBORN VALVE & FITTING CO.  
1540 N. OLD RAND ROAD  
P.O. BOX 847  
WAUCONDA, IL 60084-0847  
708-526-6900  
FAX: 708-526-1221

3	SS-600-1-4	CONNECTOR MALE TUBE FITTING	SST	4
2	P4105090804-200100	8" O.D. BEAMLINE WINDOW WELDMENT ASSEMBLY	SST	1
1	P4102020106-200001	8" I.D. BE WINDOW TUBING	SST	1
PARTS LIST				
ARGONNE NATIONAL LABORATORY				
A19149				
DESIGNED BY	DATE	DESIGNED BY	DATE	REV
FUHRMANN	8/7/94	D. SHU	10/13/94	
DESIGNED BY	DATE	DESIGNED BY	DATE	REV
J. WOTHE	10/12/94	M. KUZAY	10/13/94	
DESIGNED BY	DATE	DESIGNED BY	DATE	REV
D. SHU	10/13/94			
DESIGNED BY	DATE	DESIGNED BY	DATE	REV
D. SHU	10/13/94			
SEE PARTS LIST				
ADVANCED PHOTON SOURCE				
W4-20 BEAMLINE WINDOW				
8" O.D. (15 X 120)				
ASSEMBLY				
P4105090804-200000-00				